



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6505G00831-3G-5
Job Sheet 178818



Part No: RBW6505G00831-3G-5

Job Qty: 12 ea

Part Name: Leg



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/7/18

Job Tracking No:

Due Date: 6/11/18

Created By: Logan David

Type: SOLD

Description:

Note: URF17-785 DWG RBW6505G00831-3G Rev 2 IPP Rev A 17.11.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	6/11/18	6/11/18	0.00	0.00	Start Up Large Fab-7		OK 18/06/18
100	Waterjet	12 pcs	6/11/18	6/11/18	0.00	1.20	Waterjet 2 OMAX		OK 18/06/18
110	QC	12 pcs	6/11/18	6/11/18	0.00	0.00	QC2		OK 18/06/18
120	Mill Conv	12 pcs	6/11/18	6/11/18	0.00	3.00	Mill Conv 2		
121	QC	12 pcs	6/11/18	6/11/18	0.00	0.00	QC2 Machining-5		OK 18/06/18
122	QC	12 pcs	6/11/18	6/11/18	0.00	0.00	QC8-7		OK 18-06-18
123	HandFinish	12 pcs	6/11/18	6/11/18	0.00	2.40	HandFinish7		OK 18-06-18
130	Packaging	12 pcs	6/11/18	6/11/18	0.00	0.00	Packaging3-2		OK 18-06-18
210	QC21-SA	12 Ea	6/11/18	6/11/18	0.00	0.00	QC21		OK 18-06-18

Part Op 90 - See engineering for material sign off (MT-HRS-P)

Descriptions: 100 - 1-Cut as per Dwg (AUGUSTA FOLDER) Dwg Rev: 2 Prog Rev: 2 2-Deburr if necessary ***Note check material surface quality***

120 - Machine as per DWG.

SEE ATTACHED DEBURRED, OKAY TO SHIP 18/06/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-P-0.375	Hot Rolled Steel Plate 0.375" (44W)	2.4000 sf (.2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventor	Allocated
90-Start up Operation	MT-HRS-P-0.375	2	38	0

Part Specifications

Specifications could not be found.

Plex 6/7/18 4:38 PM dart.logan.david



Container No: S079464



Part: RBW6505G00831-3G-5

Job No: 178818

Serial No/Batch: S079464

Revision: 2

Inspector:

Instructions:

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/08/18

Under Review Notification

Raised By: VANESSA MOREL

Product #: DART TOOLING AGUSTA

Date: 17.12.14

Product Name: TROLLEY ADAPTER, TGB SUPPORT

Part Number (D-Part and 9-Digit) (eg. D3535-11) (eg. D3535-25) (eg. D206-642-143)	Drawing or Document & <u>Current</u> Affected Revision for each part listed	"Y" or "N" Required for Each Part Do not leave blank							Reserved ECN Log Number	Instructions Relevant to Each Part (including whether CHG #'s will be affected)
		HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise Customers	Stop Production	Re-Work Stock	IPP Under Review	Product Specifications Under Review ("Bluefiles")		
RBW6505G00831-3G	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress
RBW6505G00831-3G-33	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress
RBW6505G00831-3G-3	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress
RBW6505G00831-3G-5	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress
RBW6505G00831-3G-9	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress
RBW6505G00831-3G-11	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress
RBW6505G00831-3G-13	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress
RBW6505G00831-3G-15	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress
RBW6505G00831-3G-17	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress
RBW6505G00831-3G-19	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress
RBW6505G00831-3G-21	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress
RBW6505G00831-3G-23	RBW6505G00831-3G REV 2	N	N	N	N	N	Y	Y	17-785	see engineering for WO currently in progress

Description of Issue:

PRODUCTION CHANGES

RBW6505G00831-3G-25 / RBW6505G00831-3G REV 2 / N N N N N Y Y 17-785 / see engineering for WO currently in progress

A36 P&O NO AVAILABLE, MATERIAL CHANGED FOR A36/1018/1020 AND BEAD BLAST AFTER MACHINING, THEN WELDED AND SEND TO ZINC PLATED
DEVIATION HAS TO BE SIGN FOR EACH A36 PARTS

Distribution:

VP Operations

Director of Operations

Director Quality Assurance

Director of Engineering

Chief Engineer

Engineering Project Managers

Engineering Clerk

Customer Support Manager

Production Engineers

Production Planners

Purchasing Manager

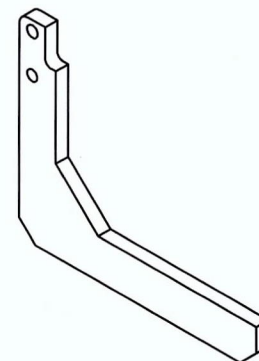
Technical Support

Product Manager - Solutions Provider

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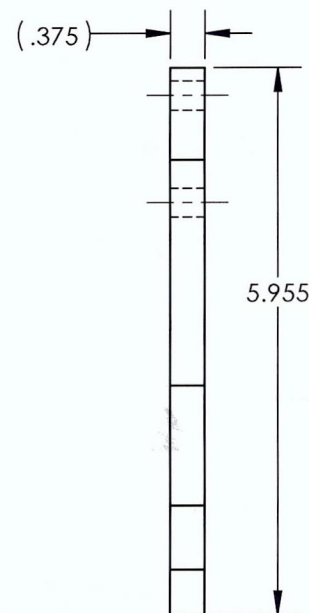
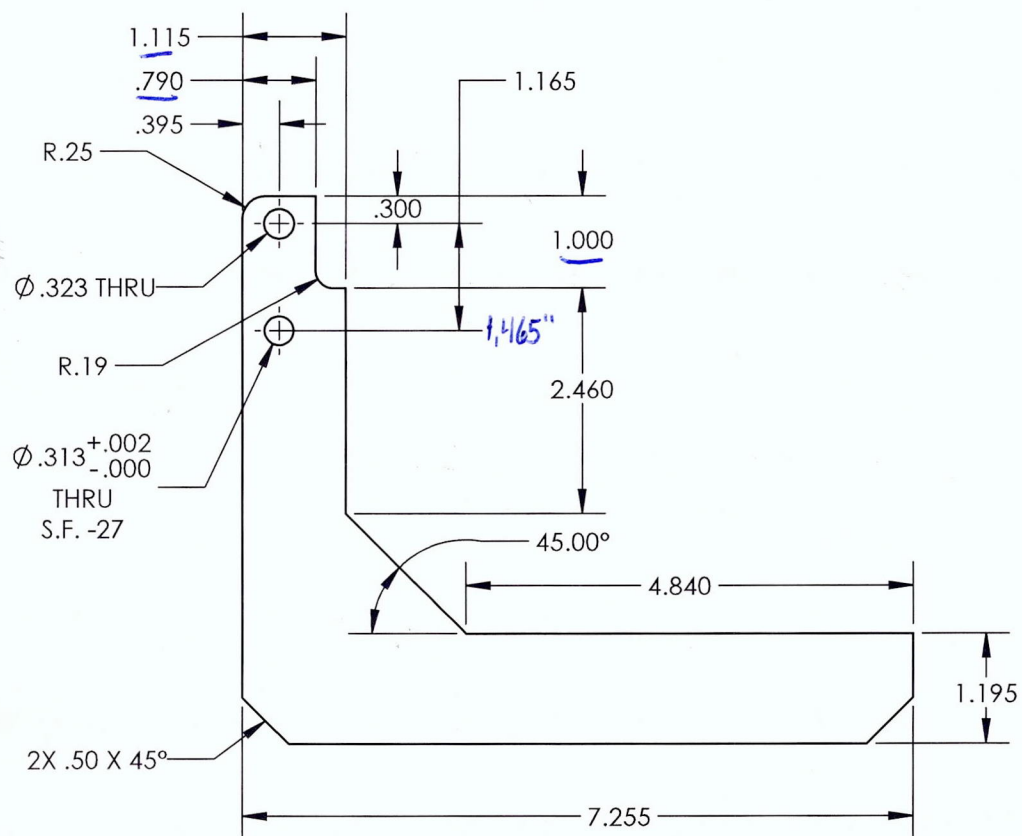
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	SHEET 5 CH'D -5 DIMENSION LOCATION WAS 6.255 IS 7.255	5/10/2013	CFS	

TEO ATTACHED



UNDER REVIEW

URF17-785 VM
17.12.14



(-5)
LEG

RED BARN MACHINE	
TITLE TROLLEY ADAPTER, TGB SUPPORT	
DWG NO. RBW6505G00831-3G-5	REV 2
MAT'L A36 P&O	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT
.XX ± .01	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	AW139
SCALE 1:2	DATE 1/20/2012
SHEET 5 OF 16	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>RBW6505G00831-3G</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval JUNE 8, 2018				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
- RBW6505G00831-3G-3 /-5/-9/-11/-13/-15/-21 material A36 P&O changed for A36/1010-1025 - Bead blast after welding - Zinc plate yellow or black per ASTM B633 type 2, class 2				- This deviation is acceptable. - The fit, form and function of the tool will be as originally intended.							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
☐ OTHER : _____											